

ABSTRACT

In a laser welding method of varying a waveform and a frequency of a laser output in a controlled manner so as to prevent occurrence of weld defects, a time change in light emission strength of a plasma or plume generated from a laser welded portion is detected, a laser output variation condition is set so that the time change in the light emission strength is in response to the variation in the laser output during laser welding.

In a laser welding method of varying the waveform and frequency of a laser output suitably so as to prevent the occurrence of the weld defects, a new laser welding method can optimize a laser output variation condition more simply and securely.